

IN THE CLAIMS

Please amend the claims as follows:

Claim 1 (Currently Amended): A method of manufacturing a product, comprising:
filling a resin containing a foaming agent into a mold cavity by injection within a time period from a time point just before completion of mold clamping to a time point after the completion of mold clamping;

allowing the resin filled in the mold cavity to form a skin layer over a surface of the resin;

retracting a movable mold to provide a predetermined cavity clearance between the movable mold and a stationary mold to cause the foaming agent to foam; and

cooling the resin filled in the mold cavity to form a foam-molded product having a tight skin layer surface and an inside portion in a foamed state,

wherein an amount of the resin to be filled into the mold cavity at the time point just before the completion of the mold clamping is between 50% and 80% of the total amount of the resin to be filled in the mold cavity.

Claim 2 (Canceled).

Claim 3 (Currently Amended): The method according to claim 1 ~~or 2~~, wherein the filling of the resin at the time point just before the completion of the mold clamping starts within a time period between five seconds before the completion of the mold clamping and the completion of the mold clamping.

Claim 4 (Currently Amended): The method according to claim 1 ~~or 2~~, wherein the resin is injected into the mold cavity at an injection speed of between 5 and 20 cm/sec.

Claim 5 (Currently Amended): The method according claim 1 ~~or 2~~, wherein a time period from starting of the filling of the resin into the mold cavity until the foaming agent

contained in an inner portion of the resin filled in the mold cavity starts foaming is between 3 and 10 seconds.

Claim 6 (Currently Amended): The method according to claim 1 ~~or 2~~, wherein a mold clamping pressure during the filling the resin into the mold cavity is between 20 kg/cm² and 100 kg/cm², and a mold clamping pressure during the allowing the resin to form the skin layer is between 20 kg/cm² and 80 kg/cm².